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RBT18632
Job Sheet 189008



Part No: RBT18632

Job Qty: 1 pcs 4

Part Name: Landing Gear Keel Bearing Install/Removal Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/17/19

Job Tracking No:

Due Date: 3/15/19

Created By: Marie Lajeunesse

Type: SOLD

Description: order 12244 ship date 18 March

Note: DWG RBT18632 REV:4 IPP REV A 18.05.28 NEW ISSUE JFC VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	3/15/19		0.00	0.33	Small Fab - 1		M/LC
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	3/15/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 38		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	1 pcs	3/15/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		



Container No: S157232



Part: RBT18632

Job No: 189008

Serial No/Batch: S157232

Revision: 4

Inspector:

Exp Date:

Instructions:

Date: 02/27/19

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					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140	QC 21 - FG	1 pcs	3/15/19	0.00 0.00	QC 21 - FG - 21	DAG
					QC 21 - FG - 70	21

Part Op 100 - Small Fab - Assemble

Descriptions: 110 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

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Job BOM

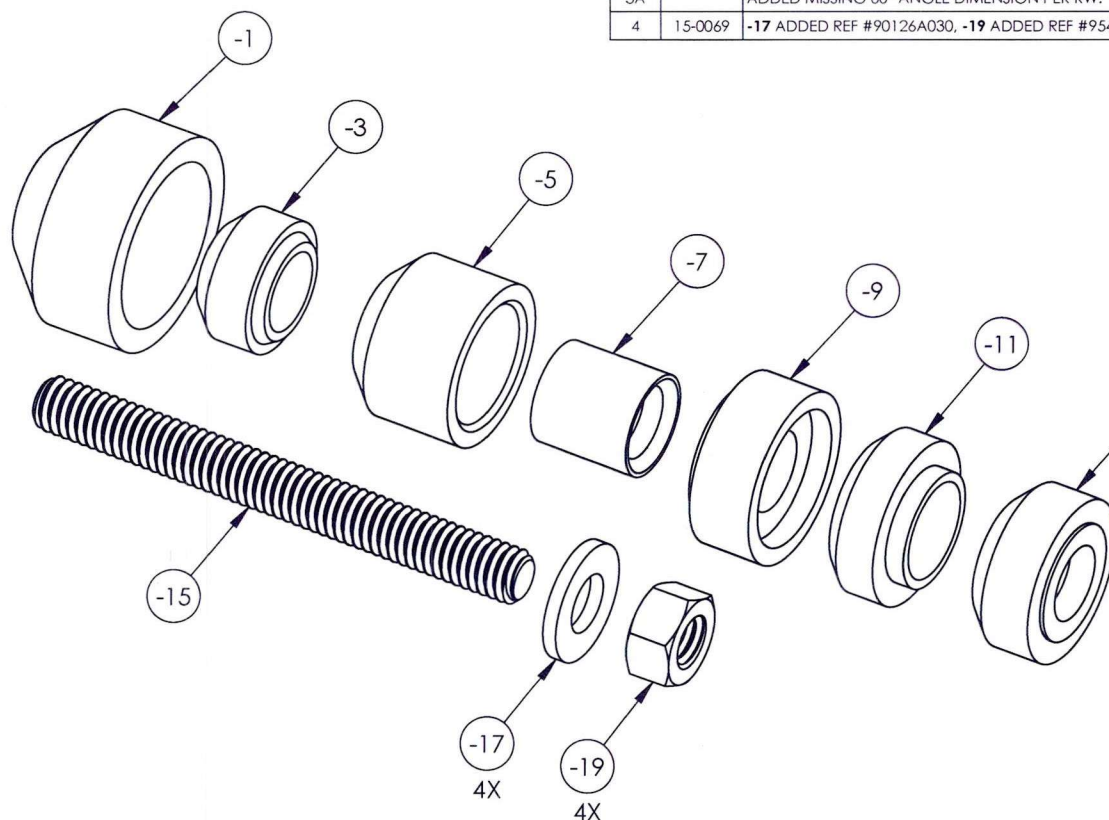
Part / Item	Component Name	Quantity	Operation	Container
90126A030	Flat Washer	4 (4 ea)	100-Small Fab - 1	5148036
95462A030	Hex Nut 5/16-18	4 Ea (4 ea)	100-Small Fab - 1	5105601
98750A045	Stud	1 pcs (1 ea)	100-Small Fab - 1	5105618
RBT18632-1	Cup	1 Ea (1 ea)	100-Small Fab - 1	5151882
RBT18632-11	Press	1 Ea (1 ea)	100-Small Fab - 1	5151932
RBT18632-13	Press	1 Ea (1 ea)	100-Small Fab - 1	5152194
RBT18632-3	Press	1 Ea (1 ea)	100-Small Fab - 1	5152205
RBT18632-5	Cup	1 Ea (1 ea)	100-Small Fab - 1	5152211
RBT18632-7	Press	1 Ea (1 ea)	100-Small Fab - 1	5152219
RBT18632-9	Seat	1 Ea (1 ea)	100-Small Fab - 1	5152231

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	90126A030	4	0	0
	95462A030	4	100	0
	98750A045	1	4	0
	RBT18632-1	1	0	0
	RBT18632-11	1	0	0
	RBT18632-13	1	0	0
	RBT18632-3	1	0	0
	RBT18632-5	1	0	0
	RBT18632-7	1	0	0
	RBT18632-9	1	0	0
Part Specifications				
Specifications could not be found.				

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
1		MODIFIED INTRENAL DIMS. FOR PRODUCTION PURPOSES.	10/9/06	
2		CH'D -3 O.D. FROM $\varnothing.780 \pm .000-.003$, AND -11 FROM $.100 \pm .003-.000$.	11/21/06	
2A		CH'D TITLEBLOCK & REVISION BLOCK, -1 THRU -13 CH'D STAMP TO ENGRAVE, REMOVED TOOL INSTRUCTIONS FROM SHEET 1, 2, 3, & 4, ADDED SHEET 5 OF 5/CUSTOMER 1 OF 1.	1/20/10	RJC RW
3		DELETED $\varnothing.515$ DIM. CH'D CHAMFER FROM $.063$ TO $.06$ PER RW.	8/7/10	RJC
3A		ADDED MISSING 60° ANGLE DIMENSION PER RW.	9/12/11	RJC RW
4	15-0069	-17 ADDED REF #90126A030, -19 ADDED REF #95462A030 TO BOM.	4/6/2015	RJC JAG



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WORK ORDER

189008 MLJ
19-01-17

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	CUP	6061		2
			-3	1	PRESS	6061		3
			-5	1	CUP	6061		4
			-7	1	PRESS	6061		5
			-9	1	SEAT	6061		6
			-11	1	PRESS	6061		7
			-13	1	PRESS	6061		8
		B/O	-15	1	STUD	B7	5/16-18 X 3 (MCMASTER-CARR #98750A045)	1
		B/O	-17	4	WASHER	STEEL	5/16 I.D. (MCMASTER-CARR #90126A030)	1
		B/O	-19	4	HEX NUT	STEEL	5/16-18 (MCMASTER-CARR #95462A030)	1

DART AEROSPACE	
TITLE LANDING GEAR BEARING TOOL	
DWG NO. RBT18632	REV 4
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: APPROVED <i>D Weil</i> HEAT TREAT FINISH SPEC USED ON MODEL MD500
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	SCALE 1:1 DATE 9/28/2006 SHEET 1 OF 9